



Dart Aerospace Ltd.
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D3168-041
Job Sheet 178737



Part No: D3168-041

Job Qty: 1 ea

Part Name: Step Assembly, Low Short LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 6/15/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 16.01.14 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/15/18	0.00	0.00	Start Up Large Fab-7		26-2018-06-25
110	Large Fab	1 pcs		6/15/18	0.00	0.10	Large Fab 8		26-2018-06-25
120	QC	1 pcs		6/15/18	0.00	0.00	QC5		CPC
130	Large Fab	1 pcs		6/15/18	0.00	0.20	Large Fab 2		CPC
140	QC	1 pcs		6/15/18	0.00	0.00	QC10		LC
150	QC	1 pcs		6/15/18	0.00	0.00	QC5		LC
160	HandFinish	1 pcs		6/15/18	0.00	0.10	HandFinish1		BE18-06-26
170	QC	1 pcs		6/15/18	0.00	0.00	QC7-5		CPC
180	Large Fab	1 pcs		6/15/18	0.00	0.10	Large Fab 8		CPC
190	QC	1 pcs		6/15/18	0.00	0.00	QC5		24-2018-06-26
200	HandFinish	1 pcs		6/15/18	0.00	0.10	HandFinish6		CPC
210	Powdercoat	1 pcs		6/15/18	0.00	0.10	Powdercoat1		24-2018-06-26
220	HandFinish	1 pcs		6/15/18	0.00	0.10	HandFinish3		24-2018-06-26
230	QC	1 pcs		6/15/18	0.00	0.00	QC3		38
290	Packaging	1 pcs		6/15/18	0.00	0.00	Packaging3-2		24-2018-06-26
300	QC21-FG	1 Ea		6/15/18	0.00	0.00	QC21		24-2018-06-26

Part Op 110 - 1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168. 2-Drill extrusion as per Dwg D3168 using Jig Descriptions: DT8680 for rivets.(Use only 1st 6holes). 3-Deburr.

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8780, as per QSI 004 & Dwg D3168 A/R Aluminum Rod 3- Grind end plate flush as per DWG.

180 - Rivet Leg Assembly as per Dwg D3168 1-Bevel end for welding 2-Inspect for foreign object as per QSI 024 3-Weld end plate as per QSI 004 & Dwg D3168 A/R Aluminum Rod 4- Grind end plate flush as per dwg

210 - START TIME: 2:40 OVEN TEMPERATURE: 320° FINISH TIME: 5:10

M156839.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 Ea (.5 ea)	90-Start up Operation	3046116
D3067-1	End Plate	1 Ea (1 ea)	90-Start up Operation	3072589
D3067-1	End Plate	1 Ea (1 ea)	180-Large Fab	3072589
D3077-1	Step Leg	2 Ea (2 ea)	180-Large Fab	164323
D3170-1	Spacer	2 Ea (2 ea)	180-Large Fab	164390
D3219-5	Plate	2 Ea (2 ea)	180-Large Fab	164390
MS20600-AD4W4	Rivet	12 Ea (12 ea)	180-Large Fab	164390

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	115	0
	D3067-1	1	276	0
180-Large Fab	D3067-1	1	276	0
	D3077-1	2	2	0
	D3170-1	2	11	0
	D3219-5	2	41	0
	MS20600-AD4W4	12	1,611	0
Part Specifications				
Specifications could not be found.				

Plex 6/7/18 8:17 AM dart.lacelle.linda

Master Unit 004060



Job No 178737

CPP: 180 Large Fab



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Container No: S083813



Part: D3168-041

Job No: 178737

Serial No/Batch: S083813

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 06/25/18